

# Process Sheet

SP117

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 32163  
Estimate Number : 10255  
P.O. Number : *N/A*  
This Issue : 5/3/2007 S.O. No. : *N/A*  
Prsht Rev. : NC  
First Issue : *N/A* Type : MACHINED PARTS  
Previous Run : 30992  
Written By : *[Signature]*  
Checked & Approved By : *[Signature]*  
Comment : Est D 00.11.81 Added inspection level 8, and removed P/O for powder coat EC

Drawing Name : MOUNTING LUG  
Part Number : D22301  
Drawing Number : D2230 REV F  
Project Number : N/A  
Drawing Revision : F  
Material : *N/A*  
Due Date : 5/20/2007  
Qty: *200* ~~300~~ Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 21.5145 f(s)  
Lug Extrusion D2423 Extrusion  
Batch: *30062*

*0207/05/22*

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
Cut D2423 extrusion to 0.82"  
Batch: \_\_\_\_\_

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
1-Machine per folio D2230-1  
(Check for crack while loading into the machine.)  
2-Tumble and deburr rough edges after tumbling

*Issue P/O-3812*  
*machine pending*  
*D 2230 REV. F*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*Revised + inspect*

*due to tired damage*

5.0 QC5 SECOND CHECK



Comment: SECOND CHECK

*inspect level 5*

*En 07/07/09*

*counted*  
*197*



Date: Thursday, 5/3/2007 11:29:52 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 32163

Part Number: D22301

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

ml 07 07 16

197 counted

(197X)

7.0

QC3

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 07/07/17

07/07/17

(197X)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

m 101575

8dmd 07-07-17

(197)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD

07/07/17

(197)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/07/27

counted

(200)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/27

(200)

Job Completion



07-07-27

0311

DA DATE

Date:

FF

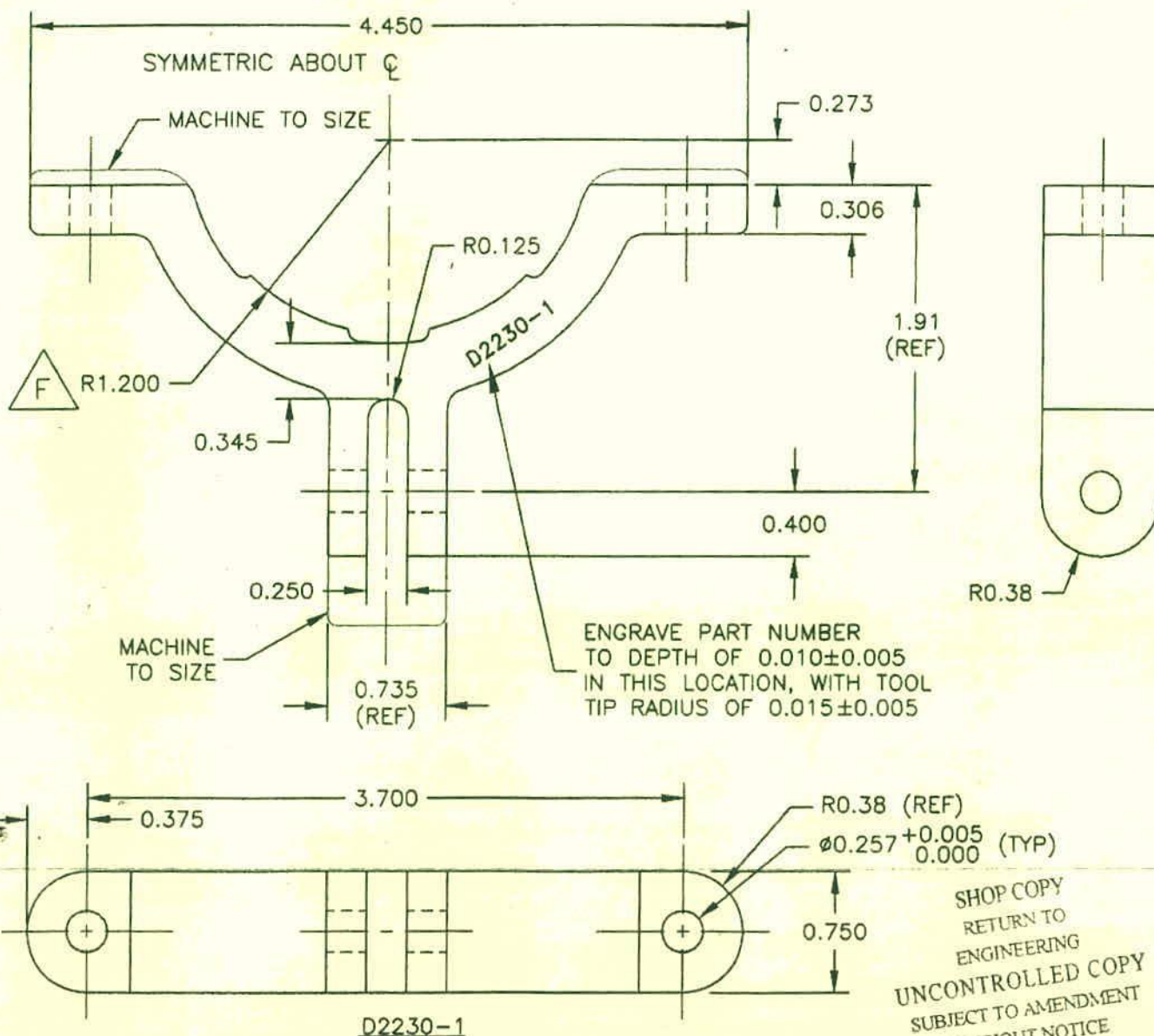
0311 0311

10

0311

**DART****RELEASED**  
99.12.21 DS

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D2230
DATE	99.12.13	TITLE	MOUNTING LUG	REV. F SHEET 1 OF 2
C	94.03.30	RE-DESIGN		SCALE 1:1
D	95.01.04	RE-DESIGN		
E	95.01.04	RE-DESIGN		
F	99.12.13	REDESIGN; R1.200 WAS R1.100		



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

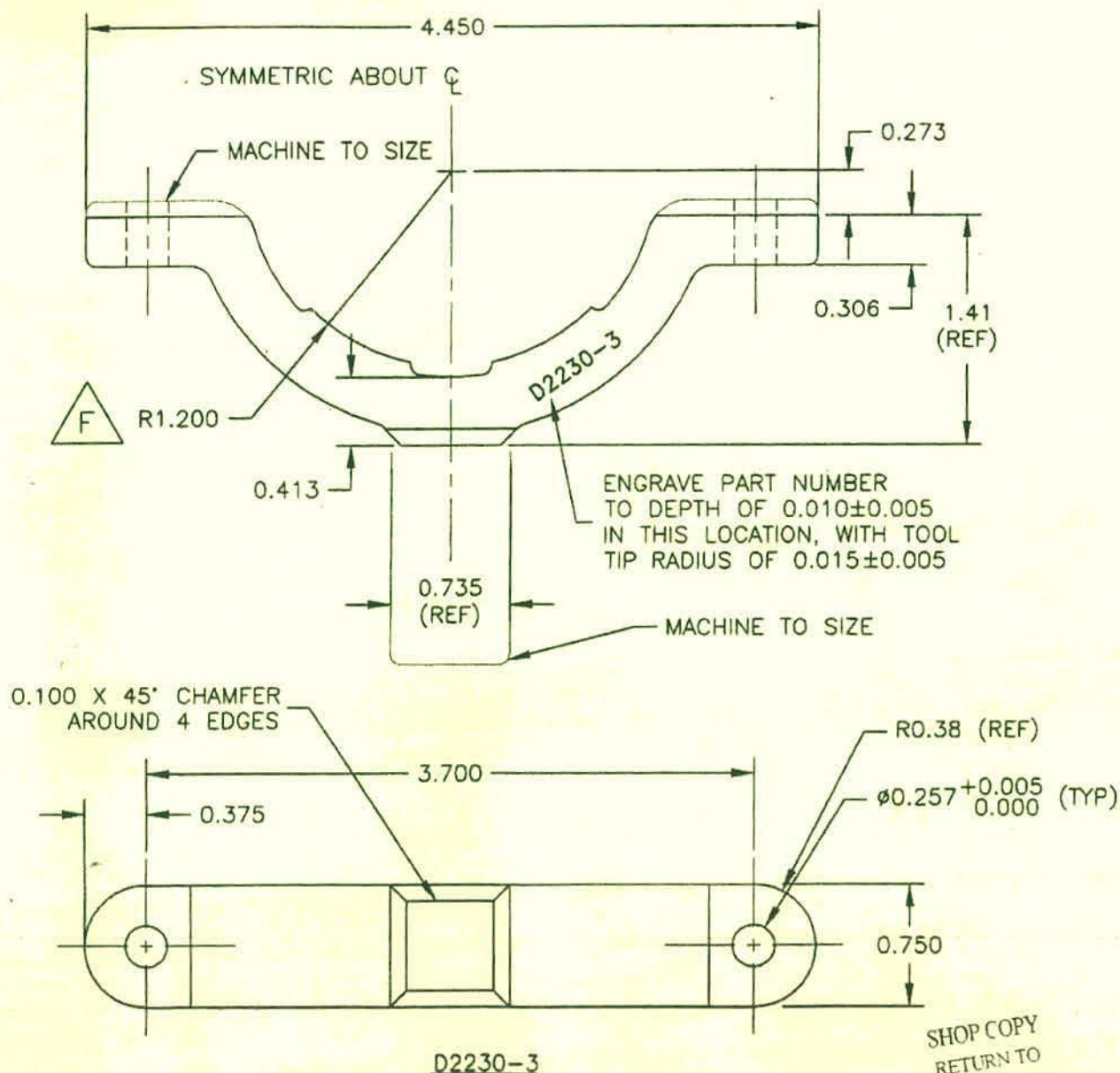
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32163





DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
79.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32163





20 Terry Fox Drive  
Vanklee Hill, Ontario K0B 1R0  
Tel: (613) 678-3957  
Fax: (613) 678-3956

**Delivery Slip No.:**

**15993**

Date:

Jul 09, 2007

Page:

1

<b>Sold to:</b>		<b>Ship to:</b>	
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7		Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	
<b>Order No.:</b> 3812		<b>Sold By:</b> Walz, Christian D.	
<b>Shipped By:</b> our truck		<b>Ship Date:</b>	

	Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1	Mounting Lug B32163	Each	370	200 ✓	
D2731-7	LUG B32387	Each	64		
D2731-7	LUG B32388	Each	64		
Cut from D2423 B30062 extrusion					
Thank you for your order!					



### CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

200

D2230-1

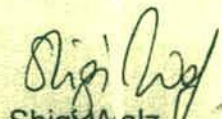
Lug B32163

3812

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi Walz

Vankleek Hill, July 9, 2007

